

Work Order ID 62848

Tuesday, October 12, 2010 11:41:49 AM

Page 1

Item ID: D350-607-043A

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

8/10/17

OK for cu 10/11/10

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10/11/10

120



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per Dwg D350-607

Seal Support Gusset with Sikaflex -291

Batch: M115114

Exp Date: 2011/01

10/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/11/17

(X)

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/17

(12)

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 10/11/17

(X)

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Page 3

Item ID: D350-607-043A

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Revision ID:

Stop

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-607-043A Location: <u>PK</u>	0.00 0.00							<u>10/11/11/SS</u>
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>CK 10/11/22</u> <u>ME 10-11-22</u> <u>A. 10.11.22</u>

W/O:		WORK ORDER CHANGES					
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Page 1

Work Order ID: 62848

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)






Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC IPP RevC: as per dwg revC DD 10.01.18 verified by:EC IPP rev:D as per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-3  Dart Logo label		Manufactured	No			110	Each	0.0000	2	2			
D350-607-241  Basket Clamp Assembly		Manufactured	No			140	Each	2.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>FG022</div> <div>2</div> <div></div> </div>													
<div> <div>61681</div> <div>2</div> <div></div> </div>													
D2022-101  Spacer		Manufactured	No			110	Each	94.0000	5	5			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST504</div> <div>94</div> <div></div> </div>													
<div> <div>50746</div> <div>23</div> <div></div> </div>													
<div> <div>52325</div> <div>11</div> <div></div> </div>													
<div> <div>61990</div> <div>60</div> <div></div> </div>													
D2221  350 Basket Base		Manufactured	No			110	Each	0.0000	1	1			
D2258-200  Placard 200lb		Manufactured	No			110	Each	12.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST505</div> <div>12</div> <div></div> </div>													
<div> <div>61760</div> <div>12</div> <div></div> </div>													

M115050 10/11/10

63348 10/11/17

10/11/10

10/11/16

10/11/10

B62852

10

10

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Page 2

Work Order ID: 62848

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2530

Manufactured No

110

Each

12.0000

1



Handle Weldment

Location

Loc Qty

Loc Code

ST506

12

60206

2

61224

10

D2535

Manufactured No

110

Each

72.0000

2



Spring

Location

Loc Qty

Loc Code

ST504

72

58331

72

D2537

Manufactured No

110

Each

54.0000

2



Bushing

Location

Loc Qty

Loc Code

ST504

54

59122

12

59423

12

62393

30

D2931

Manufactured No

110

Each

784.0000

2



Bumper

Location

Loc Qty

Loc Code

ST504

784

46064

784

D2989-041

Manufactured No

110

Each

0.0000

1



Basket Lid Assembly

B 62855

(10)

10/11/16

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Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 62848

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-043 Manufactured No



Basket Lid Assembly

D350-607-143 Manufactured No



Automatic Lid Opener Installation

AN3-16A Purchased No



Bolt

AN4-13A Purchased No



Bolt

AN4-22A Purchased No



Bolt

Location

FG032

54041

Loc Qty

1

1

Loc Code

110

Each

0.0000

1

B62862 (12)



EP 10/11/16

OK

110

Each

1.0000

1



EP 10/11/16

B63350 (12)

110

Each

98.0000

2



10/11/10

Location

ST352

114752

Loc Qty

98

98

Loc Code

110

Each

414.0000

2



10/11/10

Location

ST358

115159

Loc Qty

414

414

Loc Code

110

Each

201.0000

5



10/11/10 (12)

Location

ST359

111965

114523

114784

Loc Qty

201

2

99

100

Loc Code

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 62848

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No
Bolt

110 Each 86.0000 4

4

Location

Loc Qty

Loc Code

ST339

86

114784

46

115594

40

MS20600-AD4W3 Purchased No
Cherry Rivets

110 Each 1,569.000 2

2

Location

Loc Qty

Loc Code

ST321

1569

107939

822

111636

747

AN960JD416 NAS1149D0463J Purchased No
Washer

110 Each 24.0000 14

14

Location

Loc Qty

Loc Code

ST300

24

113288

24

AN960JD516 NAS1149D0563J Purchased No
Washer

110 Each 34.0000 4

4

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

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Work Order ID: 62848

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No

110 Each

10.0000

2 2



Washer



1115996 10/11/10

Location

Loc Qty

Loc Code

ST347

10

105059

10

NAS1515H4 Purchased No

110 Each

97.0000

2 2



Washer



10/11/10

Location

Loc Qty

Loc Code

ST277

97

111294

5

111525

92

MS21042L3 Purchased No

110 Each

2,546.000

2 2



Nut



10/11/10

Location

Loc Qty

Loc Code

ST300

2546

114523

49

114784

1497

115835

1000

2

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 62848

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,122.000

7

7



Nut

10/11/10

Location

Loc Qty

Loc Code

ST300

4122

113422

68

114523

8

114718

16

114784

32

115108

998

115589

1900

115621

1100

7

MS21042L5

Purchased

No

110

Each

895.0000

4

4



Nut

10/11/10

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

869

115156

369

115594

500

4

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Shop Packet Print

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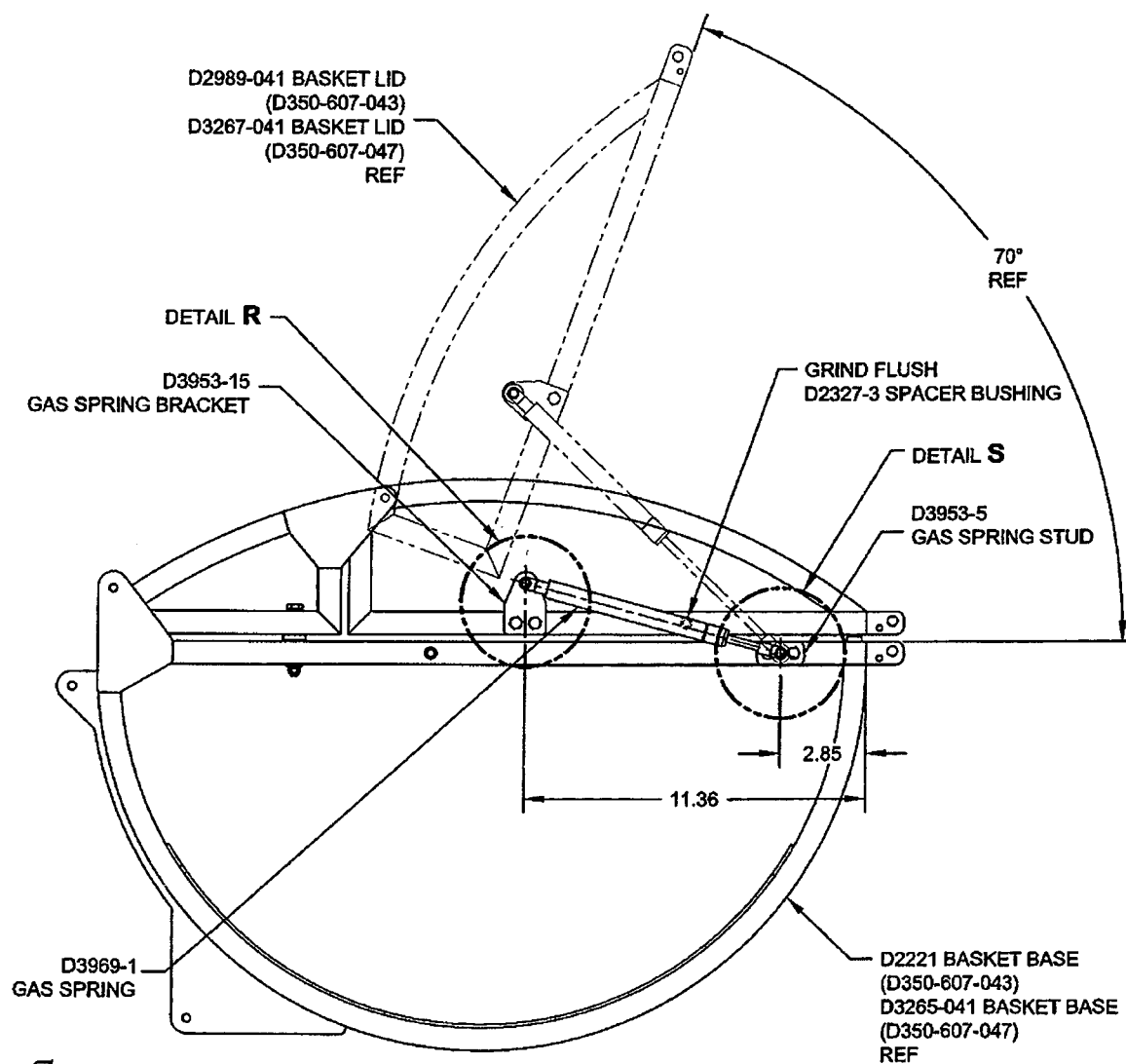
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D350-607-143 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**
Date: 10.03.10

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REVISION
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SUBMIT TO
DATE
NO. 62546
P1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.

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Revision: A
Date: 10.03.10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

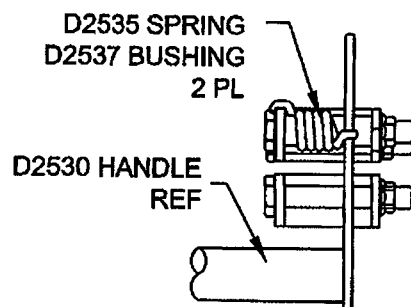
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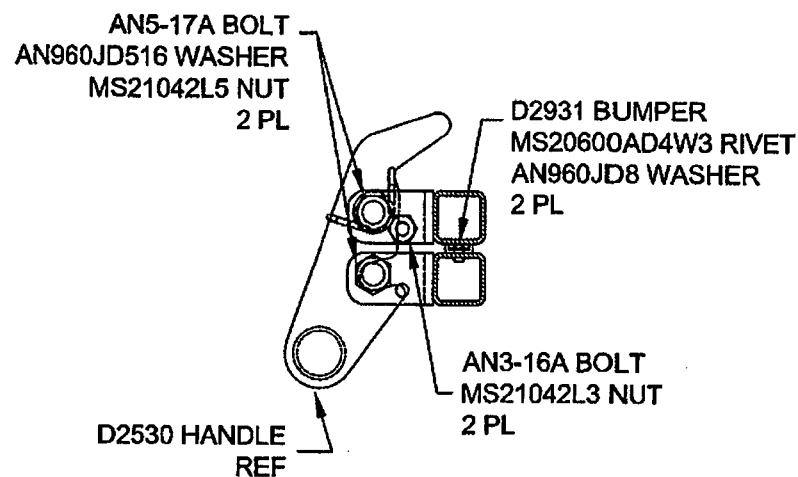
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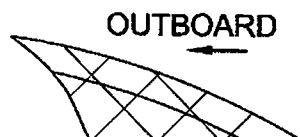


SPRING DETAIL



LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



AN4-7A BOLT
D2022-101 SPACER
AN960JD416 WASHER
MS21042L4 NUT
2 PL

AFT



W/C 62548

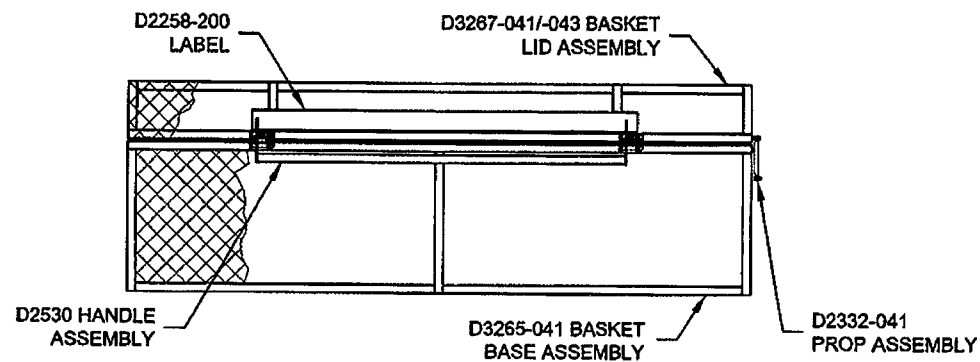
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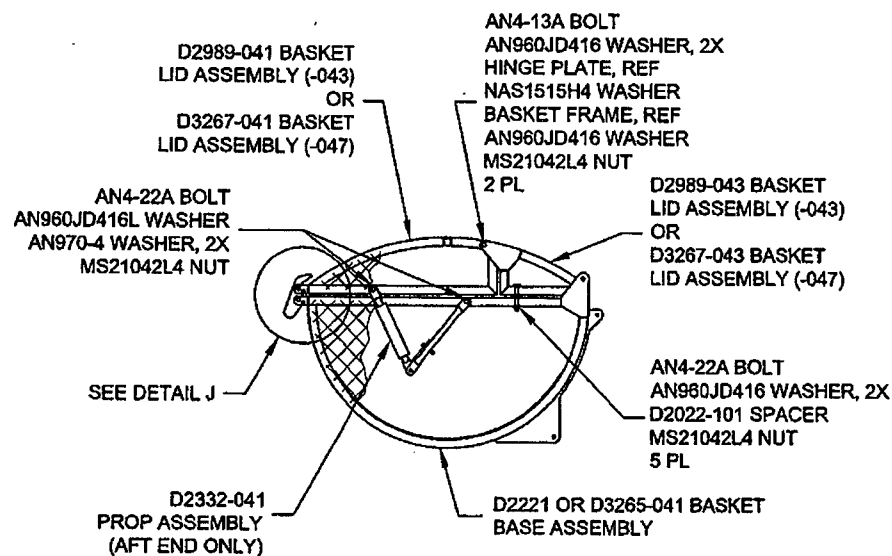
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-047 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 6– Basket Replacement Parts

u1062548

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62848

Tuesday, October 12, 2010 11:41:49 AM

Page 1



Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Stop



Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-10-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-607-1

A

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

CY 10/11/10

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

120



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: _____
Exp Date: _____